



# CEWELD 25-35Nb Tig

TYPE	Filler metal for heat resistant stainless steel with simmilar composition																		
APPLICATIONS	Joining and cladding high heat resistant CrNi-steels of the same kind and Cast steels in a low sulphurous environment.																		
PROPERTIES	Recommended for operating temperatures up to 1150° C in carburized low-Sulphur combustion gas, e. g. reforming ovens in petrochemical plants.																		
CLASSIFICATION	<table border="0"> <tr> <td>EN ISO</td> <td>14343-A: W Z 25 35Nb</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> <tr> <td>W.Nr.</td> <td>~1.4853</td> </tr> </table>	EN ISO	14343-A: W Z 25 35Nb	F-nr	6	FM	5	W.Nr.	~1.4853										
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W.Nr.	~1.4853																		
SUITABLE FOR	1.4852, 1.4853, 1.4857, 1.4837, 1.4849, 1.4848 G-X40NiCrNb35-25, G-X40CrNiSi25-12, G-X40CrNiSi25-20, G-X40 NiCrSi35-25, G-X40NiCr38-18, G-X40NiCrNb35-25, cast steels, HK40, HK45, Incoloy 800H UNS: J93503, J94204, N08705 Manaurite 36X																		
APPROVALS	No Approvals Found																		
WELDING POSITIONS																			
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Nb</th> <th>Ti</th> </tr> </thead> <tbody> <tr> <td>0.4</td> <td>0.8</td> <td>1.7</td> <td>0.01</td> <td>0.01</td> <td>26</td> <td>35</td> <td>1.4</td> <td>0.1</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Nb	Ti	0.4	0.8	1.7	0.01	0.01	26	35	1.4	0.1
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ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R<sub>p0,2</sub> MPa</th> <th>R<sub>m</sub> MPa</th> <th>A<sub>5</sub> (%)</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>480</td> <td>700</td> <td>8</td> </tr> </tbody> </table>	Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	As Welded /	480	700	8										
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As Welded /	480	700	8																
REDRYING TEMPERATURE	Not required																		
GAS ACCORDING EN 14175	I1																		



# CEWELD 25-35Nb Tig

25-35NB TIG 1,6 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663415950
25-35NB TIG 2,4 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663415967
25-35NB TIG 3,2 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663415974